

Date: Thursday, 3/30/2006 10:06:29 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: REPLACEMENT WINDOW ASSEMBLY	
Job Number	: 26454		Part Number	: D3290041	
Estimate Number	: 11174		Drawing Number	: D3290 REV A	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 3/30/2006 S.O. No. : N/A		Drawing Revision	: A	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 4/10/2006	
Previous Run	: N/A		Qty:	8	Um: Each
Written By	: See JF COMMENT Below				
Checked & Approved By	: JF 06.03.30				
Comment	: Est. B 06.05.25 Added Step 11 KJ/JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
	Comment: PURCHASING Issue P/O: <u>00000928</u> <i>AP 06/04/03</i> Manufacture D3290-1 as per Dwg.D3290 Possible Supplier: GFI Material release note is required	
2.0	D32901F	Window Frame
	Comment: Qty.: 1.0000 U(s)/Unit Total : 8.0000 U(s) Replacement Window Assy	
3.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached	<i>Apr 4/4/25 (8)</i>
4.0	QC6	DIMENSIONAL CHECK
	Comment: DIMENSIONAL CHECK	<i>Feb. 01.26 (8)</i>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr	<i>N/A</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/30/2006 10:06:29 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REPLACEMENT WINDOW ASSEMBLY

Job Number: 26454

Part Number: D3290041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Mel. F.

06.04.27

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m

06-04-28

(8)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 D2126 Seal



Comment: Qty.: 6.5000 f(s)/Unit Total : 52.0000 f(s)

Locking Seal

Pick:

Qty Part Number Description Batch

1 D2126-0780 Locking Seal B2570-2

10.0 D32901 Window Frame



Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)

Window Frame

Pick:

Qty Part Number Description Batch

1 D3290-1 Window Frame B26454

11.0 D32903 Window



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Window

Pick:

Qty Part Number Description Batch

1 D3290-3 Window B26461

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 0065104
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/30/2006 10:06:29 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REPLACEMENT WINDOW ASSEMBLY

Job Number: 26454

Part Number: D3290041

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3290

Clean D3290-041 and place in plastic wrap

5A0

06/05/02

6

13.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/05/02 (6)

14.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST106

06/05/02 (6)

15.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/05/02 (6)

Job Completion



06/05/04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

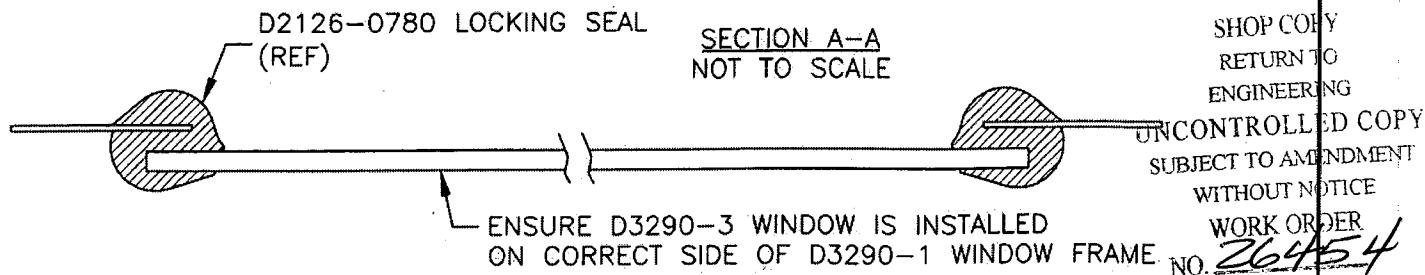
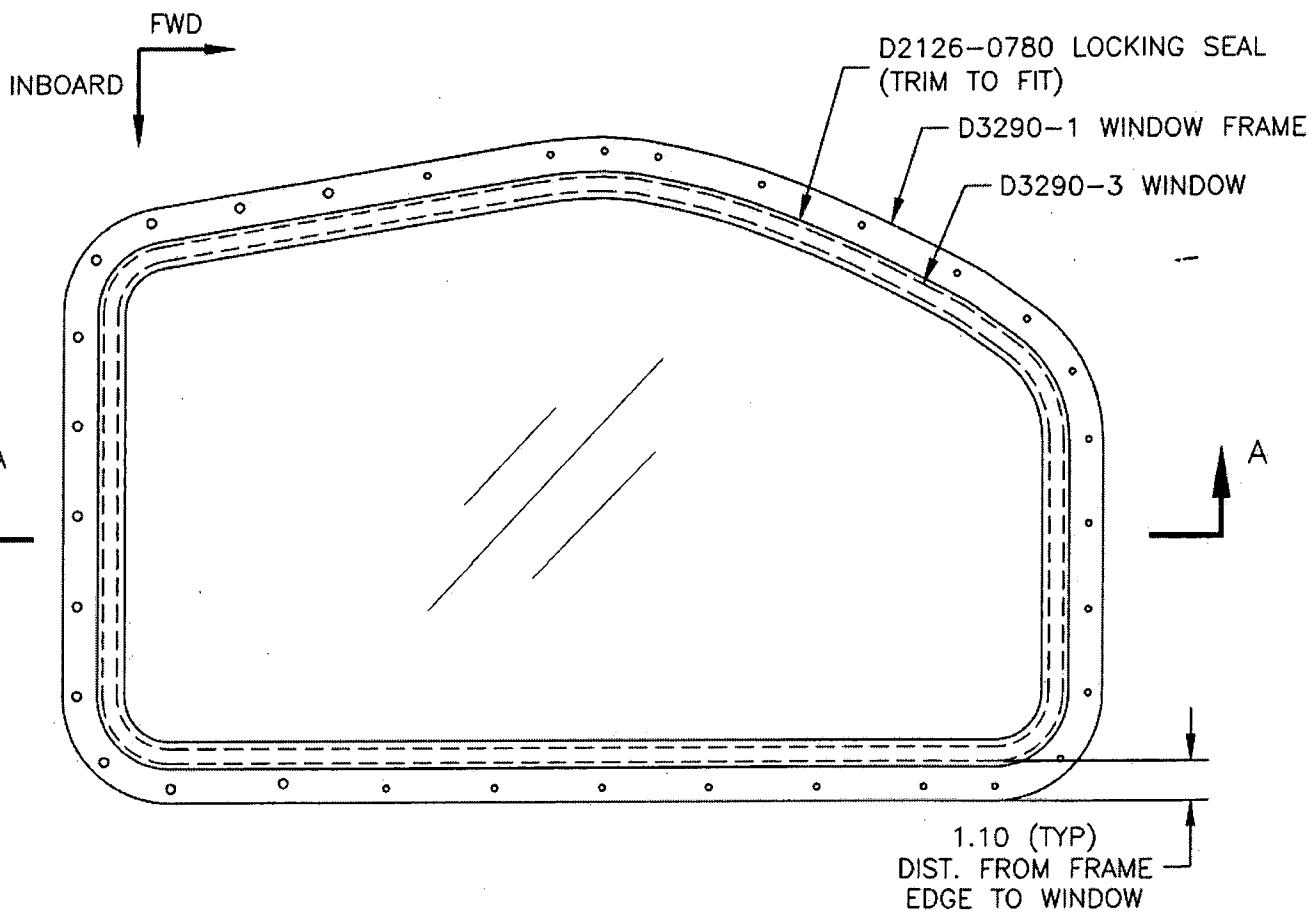
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3290	REV. A SHEET 1 OF 3
DATE 04.06.14		TITLE REPLACEMENT WINDOW ASSEMBLY	SCALE 1:5
A	04.06.14	NEW ISSUE	


RELEASED

04.07.12

NOTES

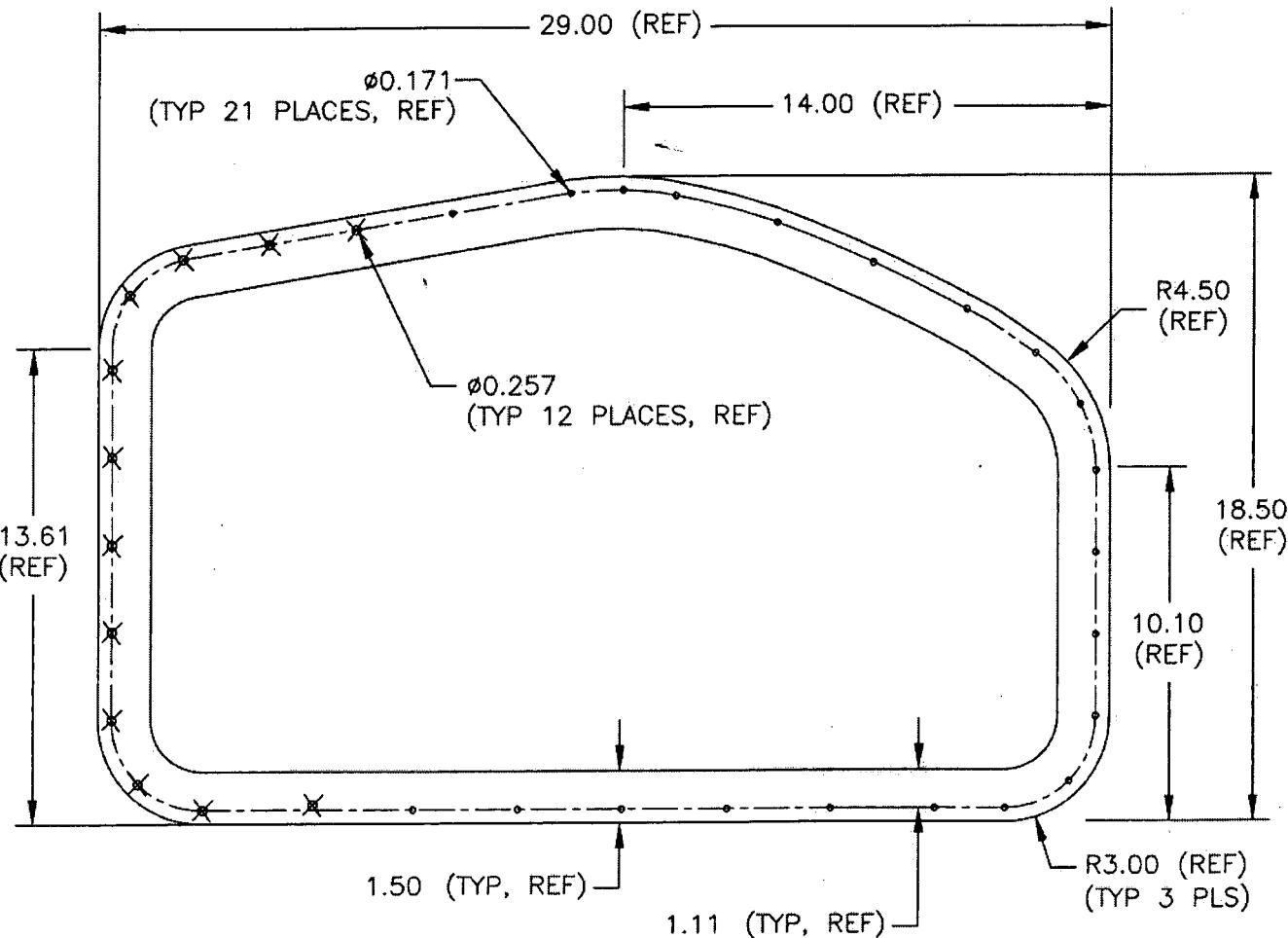
- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

DESIGN <i>RF</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>GP</i>	APPROVED <i>HF</i>	DRAWING NO. D3290	REV. A SHEET 2 OF 3
DATE 04.06.14		TITLE REPLACEMENT WINDOW ASSEMBLY	SCALE 1:5

**D3290-1 FRAME****D3290-1**

- 1) MACHINE PER DRAWING FILE "D3290-A2.DWG"
- 2) MATERIAL: 5052-H32 (QQ-A-250/8) SHEET 0.040 THICK
- 3) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

04.07.12

SHOT COPY

RETURN TO
ENGINEERINGUNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

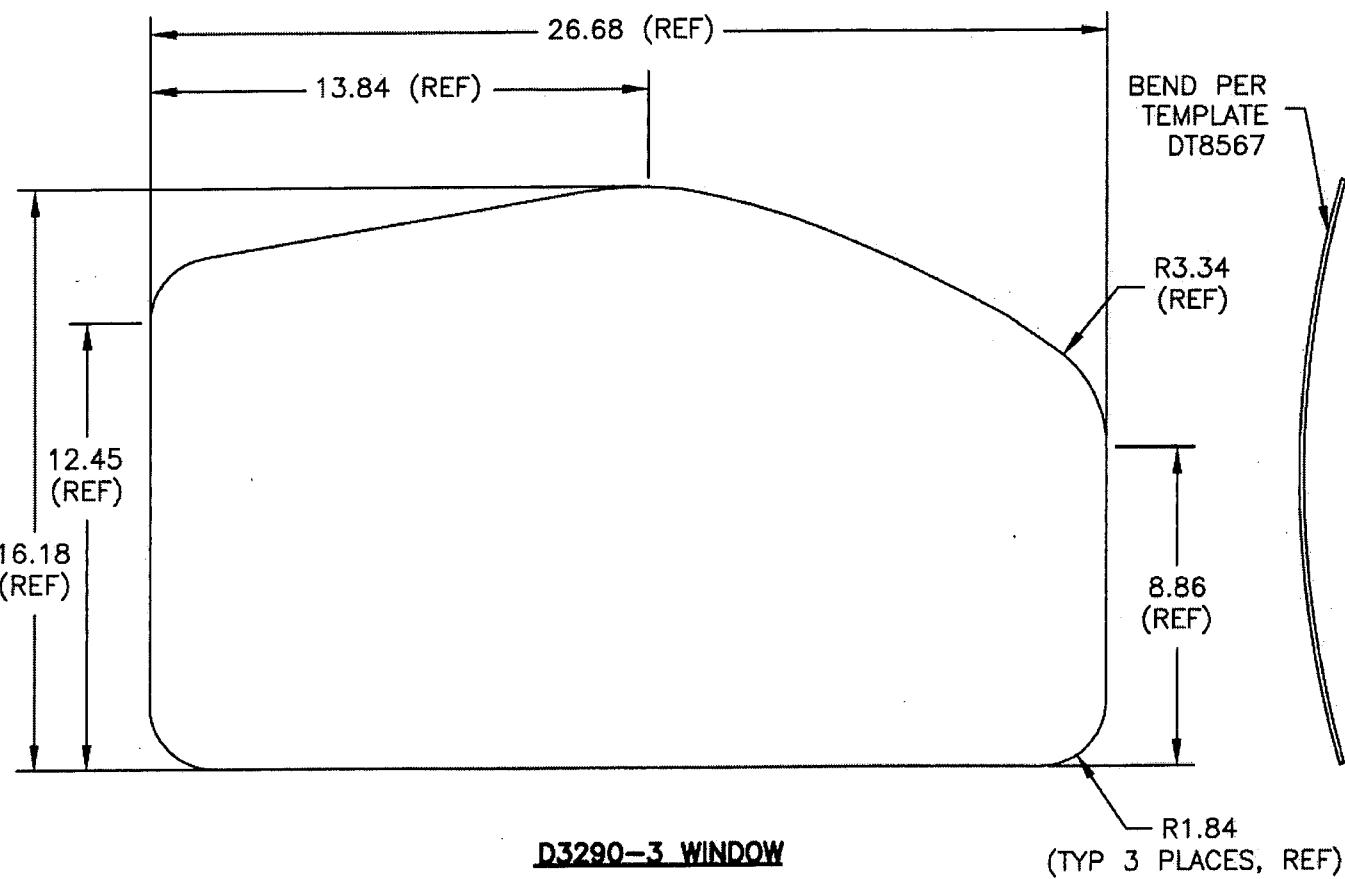
NO. 26454

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

DESIGN <i>#</i>	DRAWN BY <i>#</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>#</i>	DRAWING NO. D3290	REV. A SHEET 3 OF 3
DATE 04.06.14		TITLE REPLACEMENT WINDOW ASSEMBLY	SCALE 1:5

D3290-3

1) MATERIAL: M-ACRYLIC-S.125 (1/8" ACRYLIC SHEET)

2) ALL DIMENSIONS ARE IN INCHES

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) BREAK ALL SHARP EDGES 0.010 TO 0.020

5) CHECK PART USING DT3290-3T1

RELEASED

04.07.12

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

26454

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



180 AVENUE LABROSSE
POINTE-CLAIRE, QUÉ., CANADA H9R 1A1
TÉL.: (514) 630-4877 - FAX: (514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.



BON DE LIVRAISON - SHIPPING MEMO

DATE DE LIVRAISON SHIPPING DATE	N° BON DE LIVRAISON SHIPPING MEMO NO.
2006/04/20	0335452

VENDU À / SOLD TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7

EXPÉDIÉ À / SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7

CODE DE CLIENT CUSTOMER CODE	N° DE CONTRAT JOB NO.	N° COMMANDE PO NO.	VIA SHIP VIA
DART GFI-0299	J0141579	PO00000928	
QUANTITÉ QUANTITY	VOTRE N° DE PIÈCE YOUR PART NO.	DESCRIPTION	
8	D3290-1	FRAME CERTIFICATE OF CONFORMANCE REQ <i>10/4/25</i>	

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

REÇU PAR / RECEIVED BY

CERTIFICATE OF COMPLIANCE

CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO.	3	OUR JOB NO	J0141579	SHIPPING MEMO	0335452	
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
	8 PCS	PO00000928	D3290-1		FRAME	A
MATERIAL		SUPPLIED BY			MAT. REL. NO.	
AL 5052-H32		SAMUEL SPECIALTY			0058953 ATT'D	
PROCESS	.640		PROCESSOR	RELEASE NOTE #		
1						
2						
3						
4						
5						
6						
7						
8						
9						

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 21 APRIL 2006

G.F.I. Q.C. REP.



320-6

**LES MÉTAUX
SPÉCIALISÉS**
SAMUEL

Programme d'Assurance Qualité Enregistré / Registered Q.A. Program
ISO 9001:2000 AS9100

LETTRE DE CONFORMITÉ --LETTER OF COMPLIANCE

Date: 20 JUIN 2005

Company Name: G.F.I. Division of Thomas & Betts limited
 Address: 180 avenue Labrosse
 City: Pointe Claire, Qué.
 Zip Code: H9R 1A1

du client: 0068953 # de commande SSMQ: 842342
 Customer's order #: SSMQ's Order #:

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

Notre/Our Item #	# de pièces/ # of pieces	Epaisseur/Grandeur Guage/Size	Alliage/Trempe Alloy/Temper	Spécification / Specification	Lot/Heat
4	9	.040" X 48" X 96"	5052 H32		1388651

Bien à vous,
 Yours truly,

José Raymond

Commis à l'administration.
 Administration Clerk.



DOC : V/0080134390

DATE : 2004-11-19

PROD. REF. : 0000166327

NR : 50914/01

PAGE : 1 / 1

INSPECTION CERTIFICATE



Corus Aluminium NV.
A. Stockstraat 87, 2570 Duffel - Belgium
Tel. 32 (0)15 30 21 11 - Fax (0)15 30 27 94

CUSTOMER : CORUS ALUMINIUM ROLLED PRODUCTS US

475 N. MARTINGALE ROAD, SUITE 400
SCHAUMBURG 60173 USA

YOUR ORDER NUMBER : P02731 (SAMURAI'S PO# A15790)
OUR ORDER NUMBER : 50914/01
DOCUMENT NUMBER : V/0080134390

DESCRIPTION : ALU SHKET 5052-H12 QQA-250/8 AMS 4016 ASTM B209
DIMENSIONS : 96" X 48" X 0,04"
ARTICLE NO. :

COIL NUMBER	CAST NUMBER	CHEMICAL COMPOSITION (%)						
		Si	Fe	Cu	Mn	Mg	Cr	Zn
		MIN				2,2	0,15	
		MAX	0,25	0,40	0,10	2,8	0,35	0,10
002	1388651		0,12	0,26	0,01	0,09	2,5	0,16
		OTHERS : EACH	:		MIN	0,05 MAX		
		TOTAL	:		MIN	0,15 MAX		
TEST- NUMBER								
		MECHANICAL PROPERTIES						
		/A = REAR END	1 N/MM ² = 1 MPA = 0,1 HBAR = 0,102 KG/MM ² = 0,145 KSI	/M = MIDDLE	/V = FRONT END	/O = RANDOM SAMPLING		
		RN	RP02	A				
		KSI	KSI	%				
		MIN						
		MAX	31	23	5			
002	/M		33	29	10			

1282443
444
1445

HEAD OF LABORATORY,
XAVIER SCHELTEBENS

Corus Aluminium Rolled Products - Corus Aluminium Extrusions

